

November-21-13 2:33:09 PM

Page 1

DAS
31
9-89

14-02-67

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 109505

109505

Page 2

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Item ID: D412-704-015

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Copilot Emergency Cargo Release

Start Date: 11/21/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/21/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							DAS
Packaging	Identify and pack for shipping as per PPP D412-704-015 Location: <u>022</u>								6
	PPP Rev: _____								9-89
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

14-2-7

14-02-70

14-02-10

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WORK ORDER NON-CONFORMANCE / UPDATE

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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

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Page 1

Work Order ID: 109505

Parent Item: D412-704-015

Parent Item Name: Copilot Emergency Cargo Release

Start Date: 11/21/13

Required Date: 11/21/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 12-03-22 JLM VERIFIED BY:EC IPP REV:B 12.04.20 per cen-
566 DD verf:EC IPP REV:C 12.05.10 per ECN 12-583 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-704-141 Pedal Assembly DAS 31 9-89		Manufactured	No			110	Each	1.0000	1/12719	1		DAS 28 9-89	14-02-13
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST203		1							
				107471		1							
D412-704-045 Cable Ass'y DAS 31 9-89		Manufactured	No			110	Each	4.0000	1	1		DAS 28 9-89	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST223		4							
				101632		2							
				105341		1							
				107276		1							
D3207-5 Bracket DAS 31 9-89		Manufactured	No			110	Each	12.0000	1	1		DAS 28 9-89	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST202		12							
				101658		11							
				70293		1							
D3207-7 Packer DAS 31 9-89		Manufactured	No			110	Each	9.0000	1	1		DAS 28 9-89	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST202		9							
				100791		9							
D3207-9 Bracket DAS 31 9-89		Manufactured	No			110	Each	1.0000	1	1		DAS 28 9-89	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST202		1							
				82199		1							

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Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 2

Work Order ID: 109505

Parent Item: D412-704-015

Parent Item Name: Copilot Emergency Cargo Release

Start Date: 11/21/13

Required Date: 11/21/13

Start Qty: 1.00

Required Qty: 1.00

D3208-1
Doubler

Manufactured No

110 Each 2.0000

1 1

DAS
28
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST203

2

105253

2

Manufactured No

110 Each 7.0000

B105539
IX

DAS
28
9-89

D3208-11
Filler

DAS
31
9-89

Location

Loc Qty

Loc Code

ST202

7

103394
82201

4

3

Manufactured No

110 Each 12.0000

IX

DAS
28
9-89

D3208-3
Pedal Mount Angle

DAS
31
9-89

Location

Loc Qty

Loc Code

ST203

12

101066
102238

4

8

Manufactured No

110 Each 24.0000

IX

DAS
28
9-89

D3208-7
Filler

DAS
31
9-89

Location

Loc Qty

Loc Code

ST202

24

100978
101715

9

15

Manufactured No

110 Each 0.0000

IX

DAS
28
9-89

D3208-9
Doubler

DAS
31
9-89

D3214-1
Decal

Manufactured No

110 Each 11.0000

B98017

DAS
28
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST202

11

101709
103591

6

5

IX

November-21-13 2:33:09 PM

Shop Packet Print

Page 2

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Training									
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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 3

Work Order ID: 109505

Parent Item: D412-704-015

Parent Item Name: Copilot Emergency Cargo Release

Start Date: 11/21/13

Required Date: 11/21/13

Start Qty: 1.00

Required Qty: 1.00

D4610-1
Doubler

Manufactured No

110 Each 3.0000

☒ 1

DAS
28
9-89

14-02-6

DAS
31
9-89

Location

Loc Qty

Loc Code

ST203

3

104412

3

D4610-3
Doubler

Manufactured No

110 Each 7.0000

☒ 1

DAS
28
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST203

7

98863

7

D4610-7
Cover

Manufactured No

110 Each 5.0000

☒ 1

DAS
28
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST203

5

84418

5

MS21919-DG5
Clamp

Purchased No

110 Each 27.0000

☒ 4

DAS
28
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST321

27

125654

14

m126381

13

D4622-1
Placard

Manufactured No

110 Each 9.0000

☒ 1

DAS
28
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST114

9

103540

8

83748

1

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Shop Packet Print

Page 3

DQA: _____ Date: _____



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Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 109505

Parent Item: D412-704-015

Start Date: 11/21/13

Required Date: 11/21/13

Parent Item Name: Copilot Emergency Cargo Release

Start Qty: 1.00

Required Qty: 1.00

D4622-3 Placard	Manufactured No	110 Each 9.0000	1 1	DAS 28 9-89 14-0270
DAS 31 9-89	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
	ST114	1		
	83749	1		
	ST115	8		
	103632	8		
MS35489-149 GROMMET	Purchased No	110 Each 79.0000	1 1	DAS 28 9-89
DAS 31 9-89	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
	ST289A	79		
	121692	79		

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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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5.0 PARTS LIST

DAS
31
9-89

14-0207

Qty -011	Qty -013	Qty -015	Qty -041	Qty -141	Qty -043	Qty -045	Part Number	Description
X							D412-704-011	COPILLOT'S EMERGENCY CARGO RELEASE KIT (210/212/214)
	X						D205-704-013	COPILLOT'S EMERGENCY CARGO RELEASE KIT (205)
		X					D412-704-015	COPILLOT'S EMERGENCY CARGO RELEASE KIT (412)
1	1		X				D412-704-041	PEDAL ASSEMBLY (205/210/212/214)
		1		X			D412-704-141	PEDAL ASSEMBLY (412)
	1				X		D205-704-043	CABLE ASSEMBLY (205)
1		1				X	D412-704-045	CABLE ASSEMBLY (210/212/214/412)
			1	1			D3204-041	PEDAL ASSEMBLY (OR ECM 999702-1)
			1	1			D3205-1	PEDAL BRACKET (OR ECM 999703-1)
			1	1			D3205-3	BACK PLATE (OR ECM 999709-5)
			1	1			D3206-1	PEDAL ARM (OR ECM 999704-1)
	1						D3207-1	BRACKET
	1						D3207-3	BRACKET
1		1					D3207-5	BRACKET
1	1	1					D3207-7	PACKER
		1					D3207-9	BRACKET
1							D3207-11	BRACKET
1	1	1					D3208-1	DOUBLER (OR ECM 999709-1)
1		1					D3208-11	FILLER
1	1	1					D3208-3	PEDAL MOUNT ANGLE (OR ECM 999709-7)
	1						D3208-5	MOUNT ANGLE
1	1	1					D3208-7	FILLER (OR ECM 999709-3)
1		1					D3208-9	DOUBLER
			1	1			D3209-041	BRACKET ASSEMBLY (OR BHT 204-070-993-001)
1	1	1					D3214-1	PLACARD (OR ECM 999712-1)
					1		D3217-1	CABLE
						1	D3217-3	CABLE
					1	1	D3257-1	FITTING
					1	1	D3258-1	ANGLE BRACKET
		1					D4610-1	DOUBLER
		1					D4610-3	DOUBLER
			1	1			D4610-5	SHIM
		1					D4610-7	COVER
				1			D4611-1	BUSHING
		1					D4622-1	PLACARD
		1					D4622-3	PLACARD
			1	1			AN3-10A	BOLT
					1	1	AN3-13A	BOLT
			1	1			AN315-4R	NUT
					1	1	AN3-5A	BOLT
			2	2			AN3-6A	BOLT
			1	1			AN4-10A	BOLT
			2				AN4-11A	BOLT
				2			AN4-12A	BOLT
			1				AN4-13A	BOLT

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Revision: C

Date: 12.04.12

REFERENCE ONLY

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IIN-D412-704

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Qty -011	Qty -013	Qty -015	Qty -041	Qty -141	Qty -043	Qty -045	Part Number	Description
				1			MS20002-4	WASHER
				1			MS20004-24	BOLT
			3	3	2	2	MS21042L3	NUT (OR MS21042-3)
			5	5			MS21042L4	NUT (OR MS21042-4)
4	4	4					*MS21919DG5	CLAMP
			1				MS24694-S102	SCREW
				1			MS24694-S104	SCREW
	2						MS35489-10	GROMMET
		1					MS35489-149	GROMMET
			1	1			MS9519-10	BOLT
			4	4	2	2	NAS1149D0332J	WASHER (OR AN960JD10L)
			5	5	2	2	NAS1149D0363J	WASHER (OR AN960JD10)
			3	2			NAS1149D0416J	WASHER (OR AN960JD416L)
			14	13			NAS1149D0463J	WASHER (OR AN960JD416)
					3	3	NAS509-3	NUT

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Revision: C

Date: 12.04.12

Work Order ID 109505

109505

Page 1

November-21-13 2:33:09 PM

Item ID: D412-704-015

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Copilot Emergency Cargo Release

Start Date: 11/21/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/21/13 Req'd Qty: 1.00

1

Customer:

Reference:

Run

Start

NR1

Approvals: Process Plan: MLJ

Date: 13-11-22 Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN-D412-704	C
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100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Photocopy bluefile and create labels per PPP D412-704-015 CHG002

Document Control

MLJ 14-02-06

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

IX

DAS

28

9-89

14-02-06

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control